

Date: Tuesday, 07/10/2008 10:16:46 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: LEFT ARM WELDMENT
<b>Job Number</b>	: 42498		
<b>Estimate Number</b>	: 11871		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D33549
<b>This Issue</b>	: 07/10/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3354
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 31584	<b>Drawing Revision</b>	: C
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/10/2008
<b>Checked &amp; Approved By</b>	: <u>JUL 08 10 07</u>	<b>Qty:</b>	(10) Um: Each
<b>Comment</b>	: est. rev.A 06.01.14 new issue EC rev B 07.03.23 rev B dwg ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1020TR1250W219	Round Tubing 1.250 x .219w



M1018R1.625  
JUL 08.10.21



(10)

Comment: Qty.: 0.2405 f(s)/Unit Total: 2.4045 f(s)

Seamless Round Tubing

AISI 1020 1.25" OD x .219" wall

batch: M11/219

MME 08/10/27

2.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



(10)

Comment: CONVENTIONAL LATHE

1-Turn as per dwg D3354

2- Deburr

MME 08/10/27

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



(10)

Comment: CONVENTIONAL MILLING MACHINE

1-Drill hole, mill flat &amp; c'sink as per dwg D3354

2- Mill angle on end as per dwg D3354

3- Deburr

MME 08/10/27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



(10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MME 08/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/10/2008 10:16:46 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 42498

Part Number: D33549

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 08/10/27*

*(10)*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Cal*

*8/10/27*

*(10x)*

*sp*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*2 08/10/27*

*(10)*

Job Completion



*11 08/10/28*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42498
<b>Description:</b> Handle Socket		<b>Part Number:</b> D3354-9
<b>Inspection Dwg:</b> D3354	<b>Rev:</b> B	<b>Page 1 of 1</b>

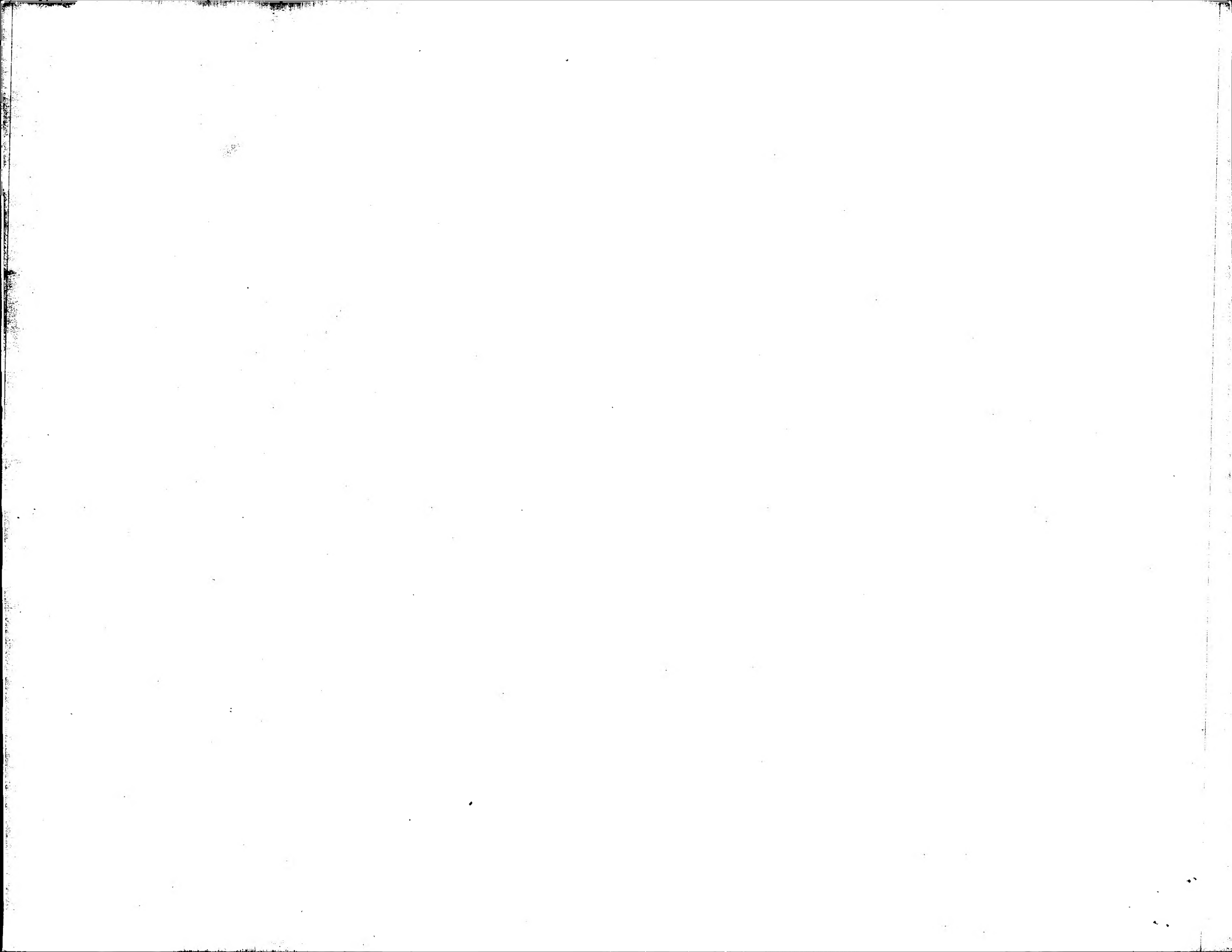
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.50	+0.012/-0.001	Ø1.50	✓			
Ø1.062	+0.012/-0.001	Ø1.066	✓			
0.219 Ref	+/-0.010	.217	✓			
2.50	+/-0.030	2.50	✓			
0.32 Ref	+/-0.030	.33	✓			
Ø1.437	+0.012/-0.001	Ø1.437	✓			
30°	+/-0.5°	30°	✓			
0.86	+/-0.030	.88	✓			
0.110	+/-0.010	.105	✓			
100°	+/-0.5°	100°	✓			
18°	+/-0.5°	18°	✓			
R0.06	+/-0.030	R.062	✓			
0.78 Ref	+/-0.030	.81	✓			
0.43	+/-0.030	.43	✓			
Ø0.397	+0.006/-0.001	Ø.398	✓			
Ø0.550	+0.008/-0.001	.550	✓			

<b>Measured by:</b> mmf	<b>Audited by:</b> mmf	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/10/27	<b>Date:</b> 08/10/27	<b>Date:</b>	N/A

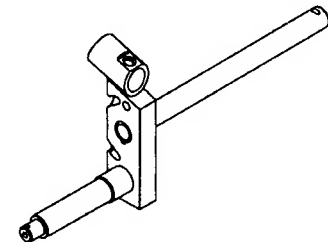
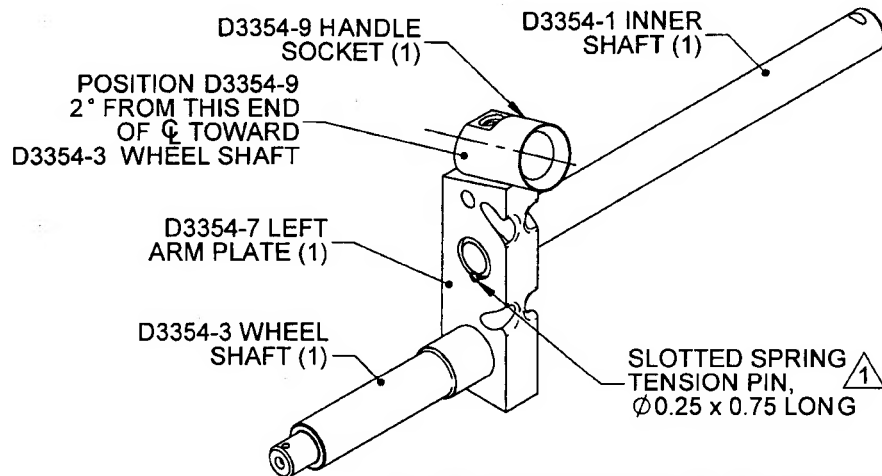
Rev	Date	Change	Revised by	Approved
A	07.04.20	New Issue	KJ/JLM	[Signature]





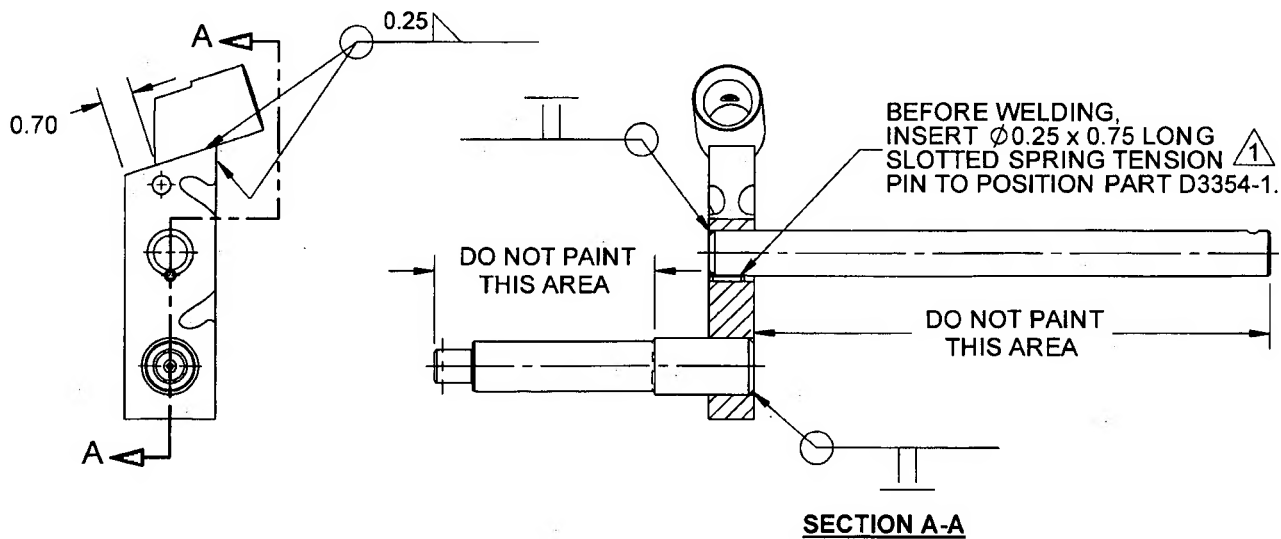
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CHECKED <i>lb</i>	APPROVED <i>WJ</i>	DRAWING NO. <b>LEFT ARM WELDMENT</b>	REV. C SHEET 1 OF 7
DATE <b>07.12.06</b>		TITLE <b>D3354</b>	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	
C	07.12.06	CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT	

RELEASED  
07/12/07 *WJ*



**D3354-042 MIRROR  
ARM WELDMENT**

**D3354-041 LEFT ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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NO. *42498*

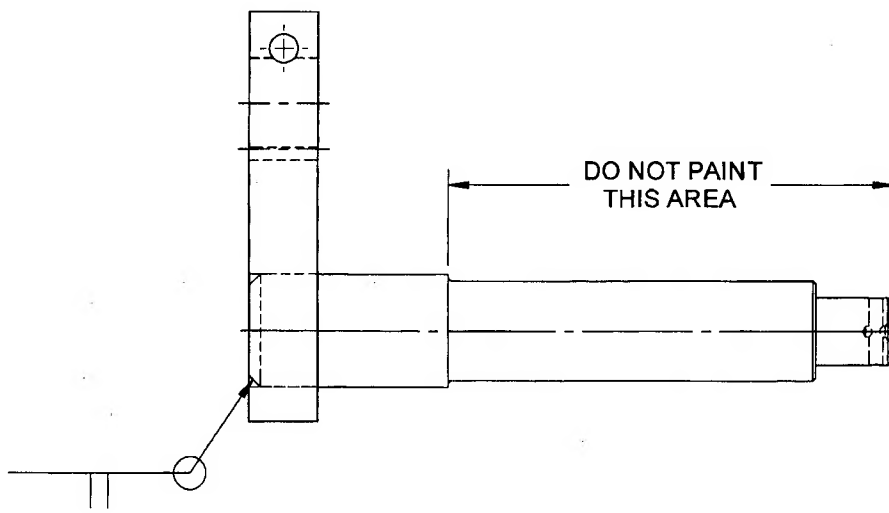
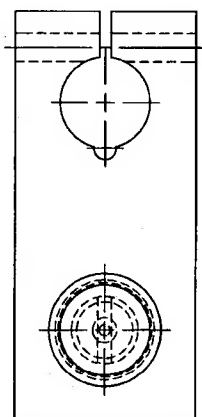
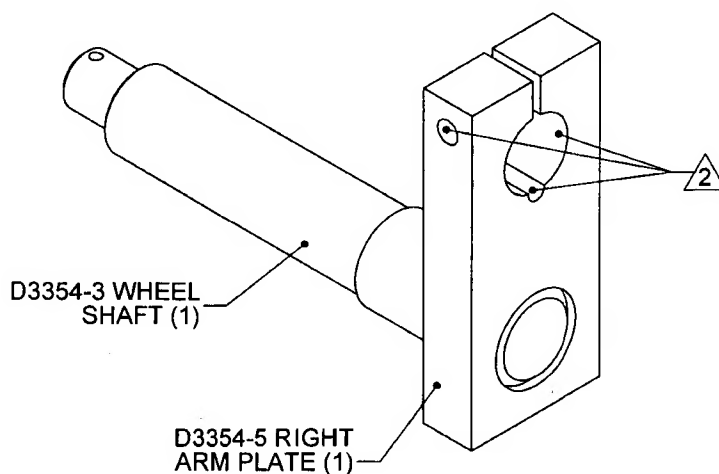
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DATE <b>07.12.06</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:2

RELEASED  
01/12/07 *W/O*



**D3354-043 RIGHT ARM WELDMENT**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3 NO. *42498*
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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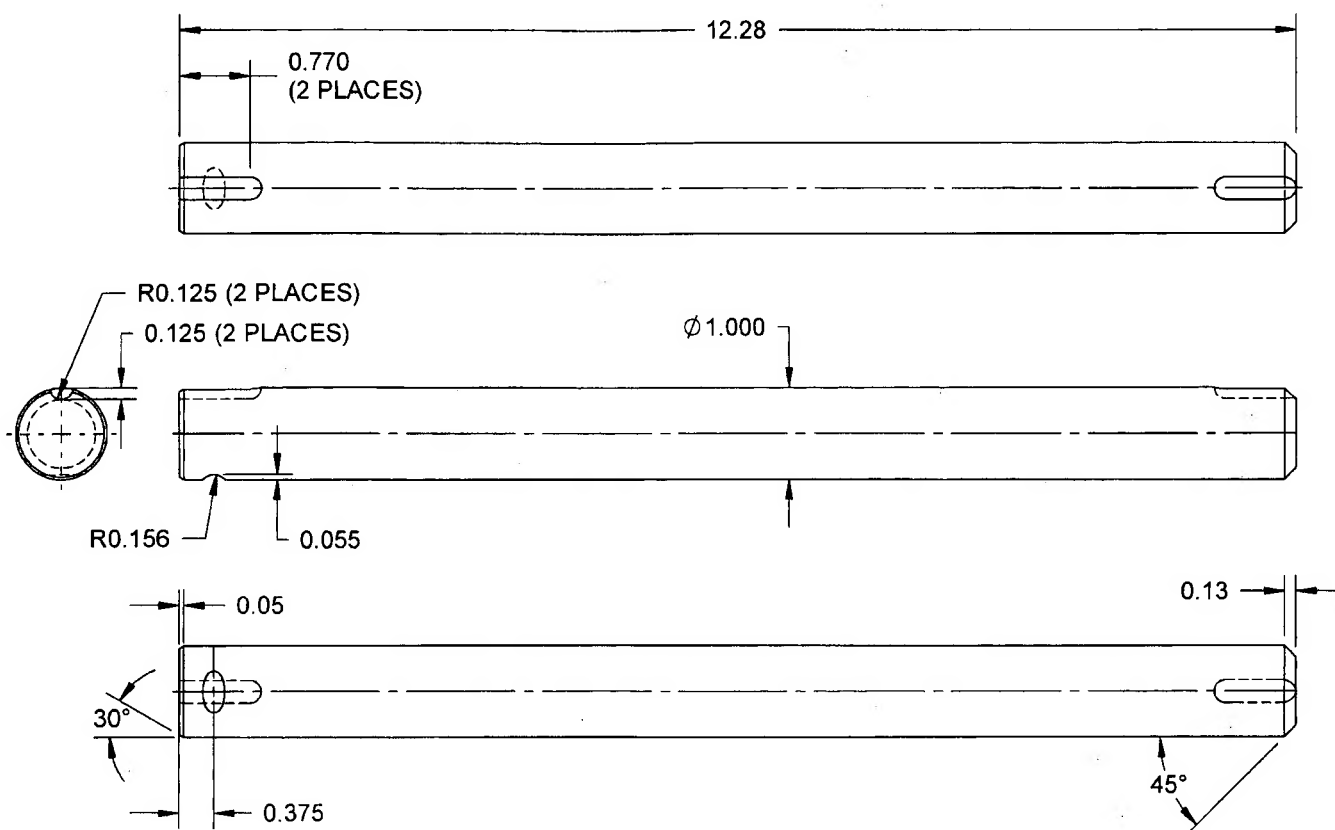
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED  
07/12/07 *WJ*



### D3354-1 INNER SHAFT

#### NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-01  
OR UNS#-G41400 ROUND BAR,  $\phi$ 1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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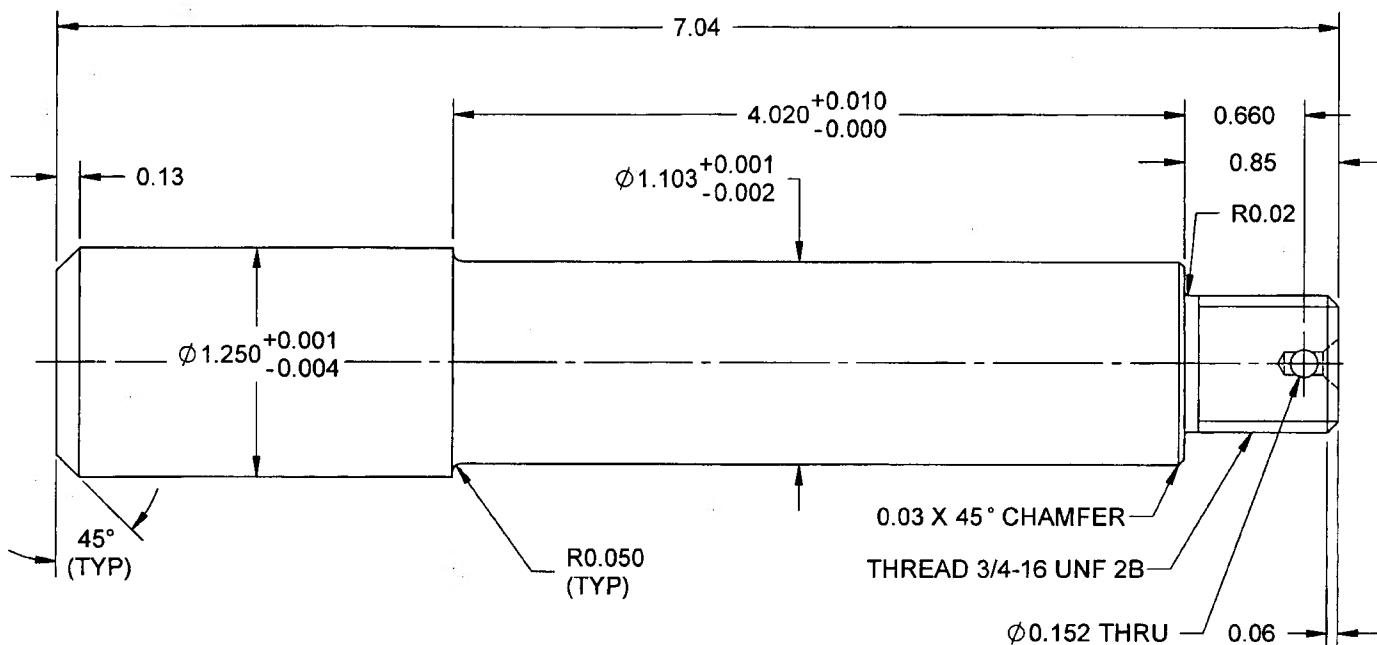
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CHECKED <i>JS</i>	APPROVED <i>WP</i>	DRAWING NO. <b>D3354</b>	REV. C SHEET 4 OF 7
DATE <b>07.12.06</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:1

RELEASED  
07.12.07 *WP*



**D3354-3 WHEEL SHAFT**

**NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/A322-01 OR UNS#-G41400 ROUND BAR,  $\phi$  1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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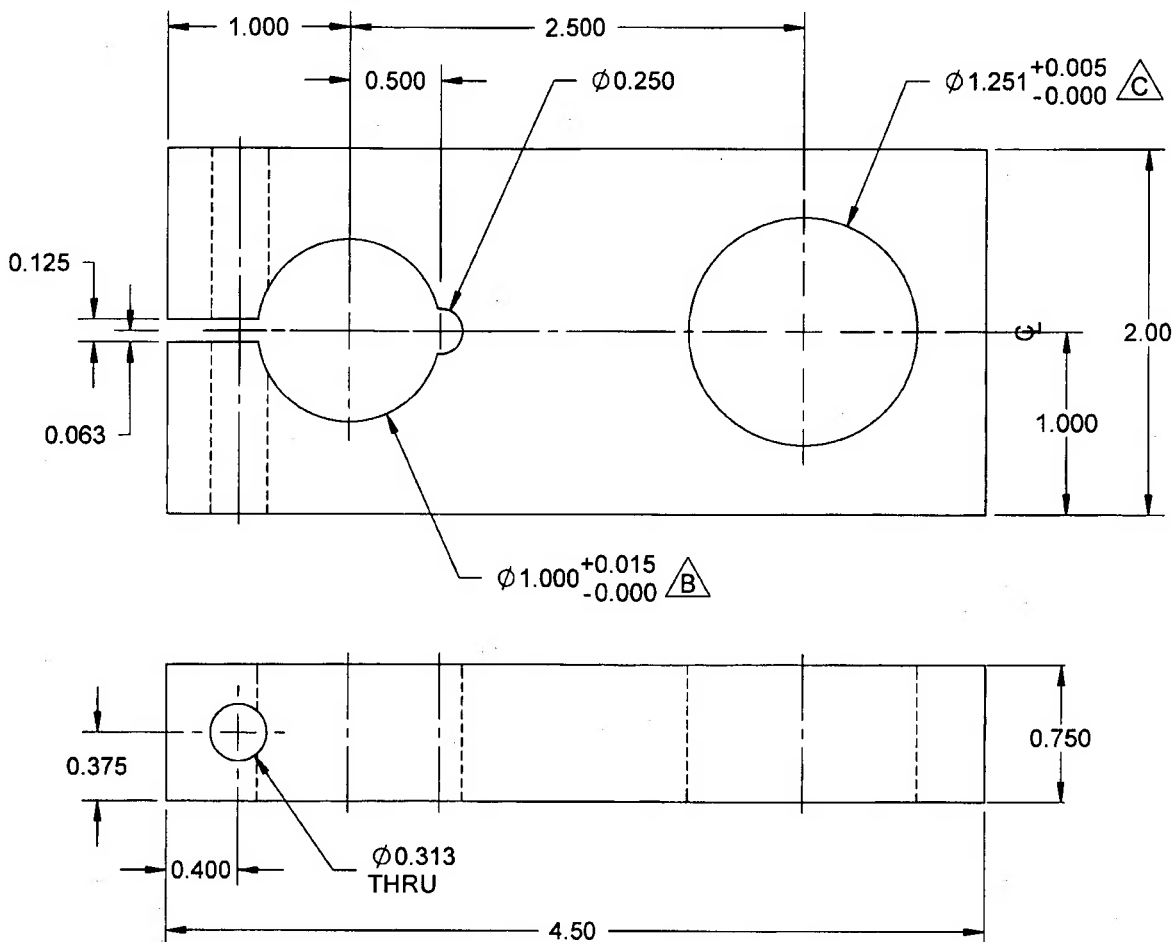
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DATE <b>07.12.06</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:1

RELEASED  
07/12/07 *[Signature]*



### D3354-5 RIGHT ARM PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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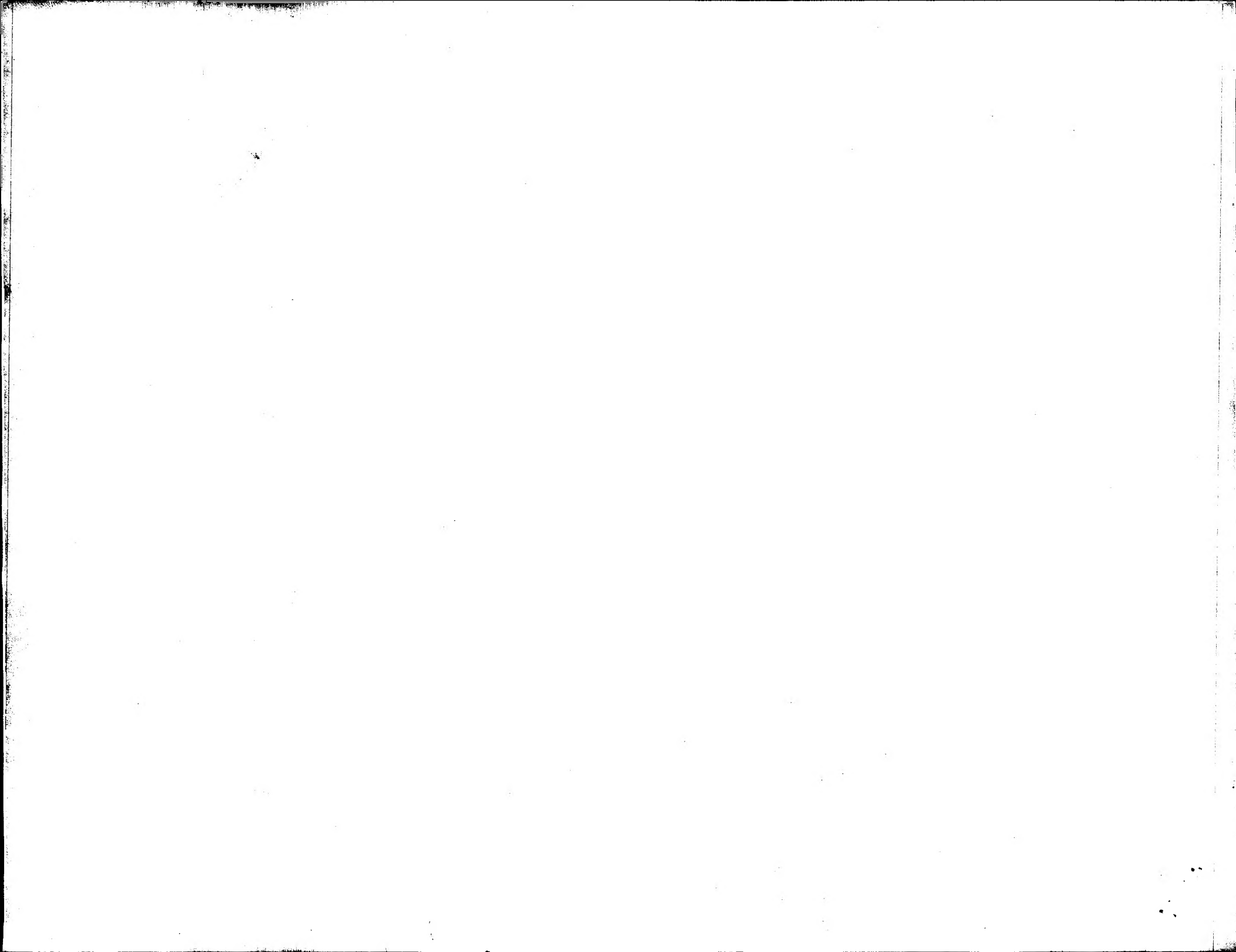
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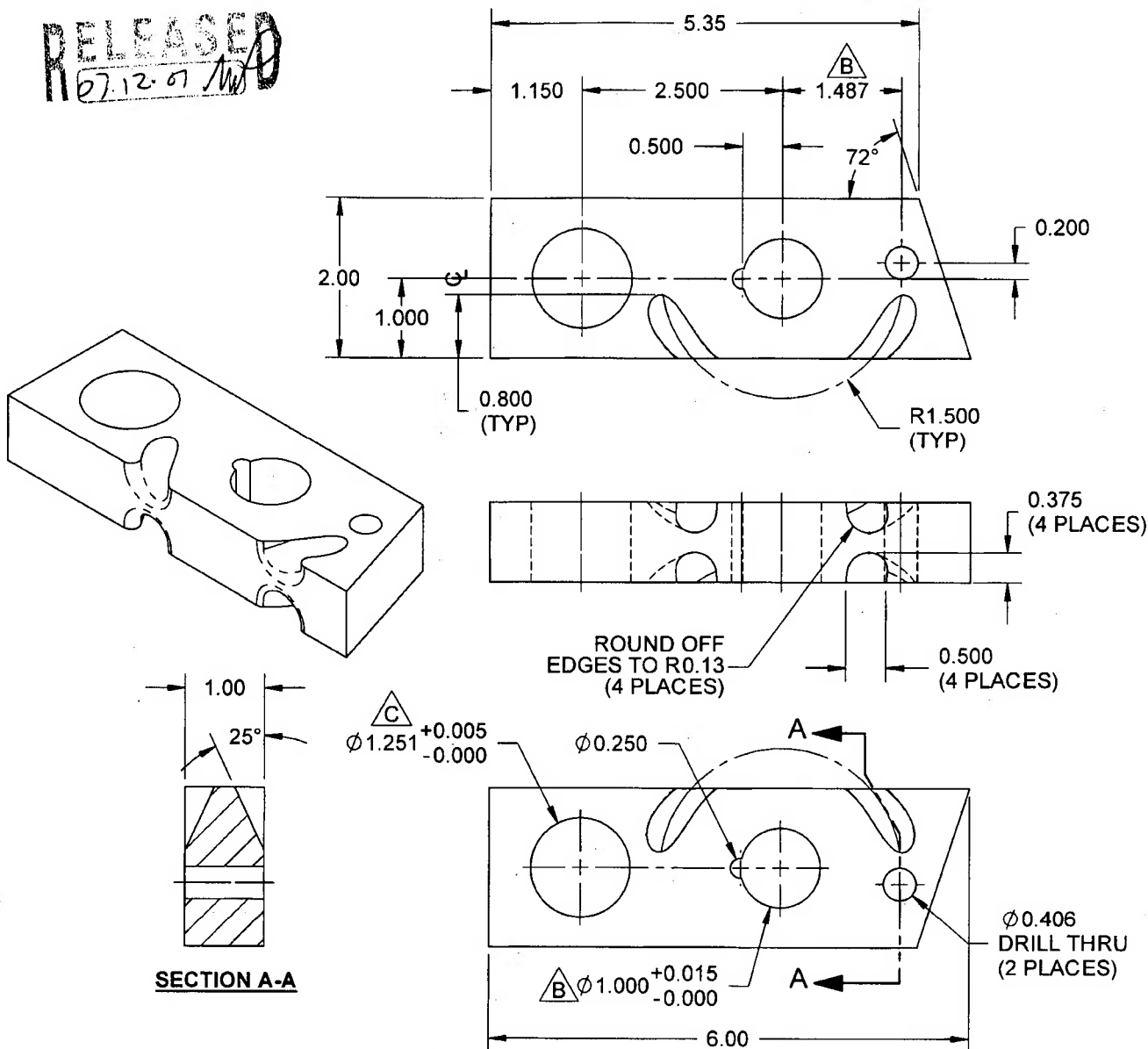
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DATE <b>07.12.06</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:2

**RELEASED**  
07.12.07 *MA***D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

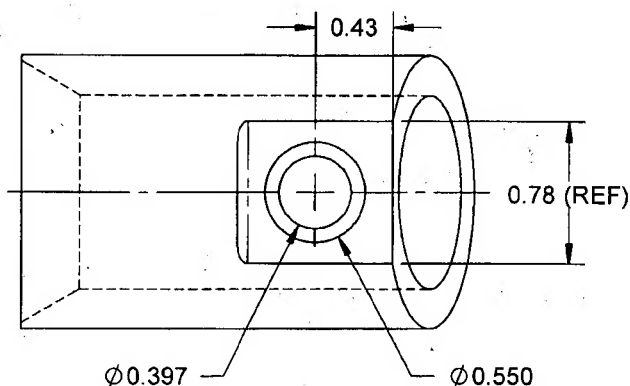
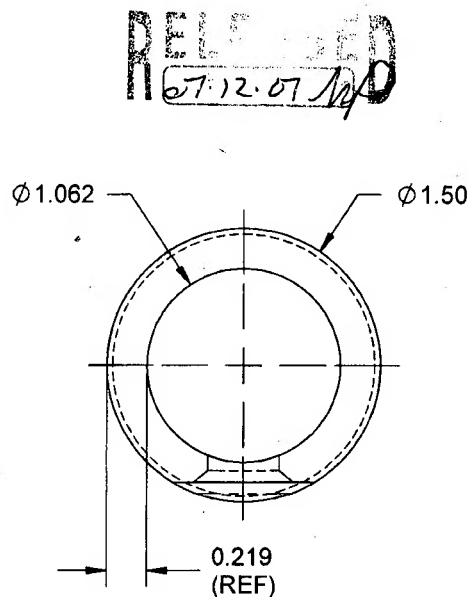
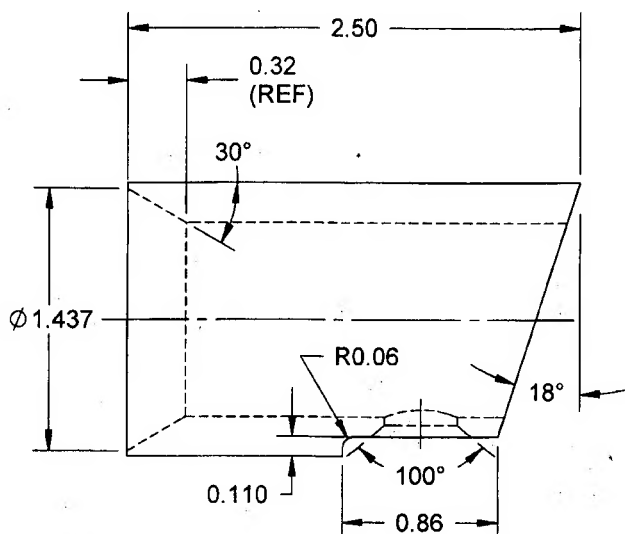
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1



### D3354-9 HANDLE SOCKET

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAM LESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
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